

Work Order ID **76207**

76207

Page 1

November-07-11 2:37:02 PM

Item ID: D3195-041
 Revision ID:
 Item Name: Bracket Assembly
 Start Date: 07/11/2011 Start Qty: 6.00
 Required Date: 21/11/2011 Req'd Qty: 6.00
 Reference:

Accept

N9000040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: M.L.J Date: 11/11/08 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3195	Rev A								

100
100 BAND SAW 0.00
 Bandsaw Memo 0.00 11/12/13 10
 Jeaspa Bandsaw Cut blanks: (0.75" x 2.00") x 3.60" long

110
110 HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS Punch Memo 0.00 CX 11/12/14 10
 HAAS CNC vertical machine #1 Machine D3195-1 as per Folio PA334 and Dwg D3195 Identify as D3195-1 Debur

120
120 QC rec'd Memo 0.00
 Quality Control

rec'd + inspect for transit damage
attached c/c to w/o

01/21/13 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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November-07-11 2:37:02 PM

Item ID: D3195-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 07/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC - Inspect parts - second check Memo	0.00 0.00				<u>W</u>	<u>12</u>	<u>02</u>	<u>23</u> (10)
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>A2</u>	<u>12</u>	<u>2</u>	<u>23</u> (10)
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: <u>10:00</u> OVEN TEMPERATURE: FINISH TIME: <u>3200 F</u> <u>10:30</u>	0.00 0.00							<u>10X2 M / 12/02/27</u>

W118484

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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 Required Date: 21/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 QC3- Inspect Part Finish 0.00

160

QC Memo 0.00

Quality Control

10 12/02/27

170 Small Fab 0.00

170

Small Fab Memo 0.00

Small Fab 1-Lightly Sand bonding surface2-Bond D3195-5 into D3195-1 as per Dwg
 D3195A/RContact Cement

Setch Weld
 12/22/34
 1300M neoprene High Performance
 12/15/27

10 FF 12-02-27

180 QC5- Inspect part completeness to step on W/O 0.00

180

QC Memo 0.00

Quality Control

8/12/27

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

01212754 142

MLJ 12102128

MF 12-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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November-07-11 2:37:07 PM

Work Order ID: 76207

76207

Parent Item: D3195-041

D3195-041

Parent Item Name: Bracket Assembly

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3195-5		Manufactured	No			100	Each	2.0000	1	6			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3195-5

Pad

**

(10) FF 12-02-27

Location

Loc Qty

Loc Code

GA

2

* B 80687

B 79046

2

6

75065

2

2

M6061T6B0.750X02.00
0

Purchased No

170

f

16.1850

0.3

1.894737

M6061T6B0.750X02.000

**

6061-T6 Bar .750 x 2.00

Location

Loc Qty

Loc Code

MAT003

16.185

100742

3.271

111448

12.914

1.9 11/12/13

D3195-1P

X 10

12/12/23 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

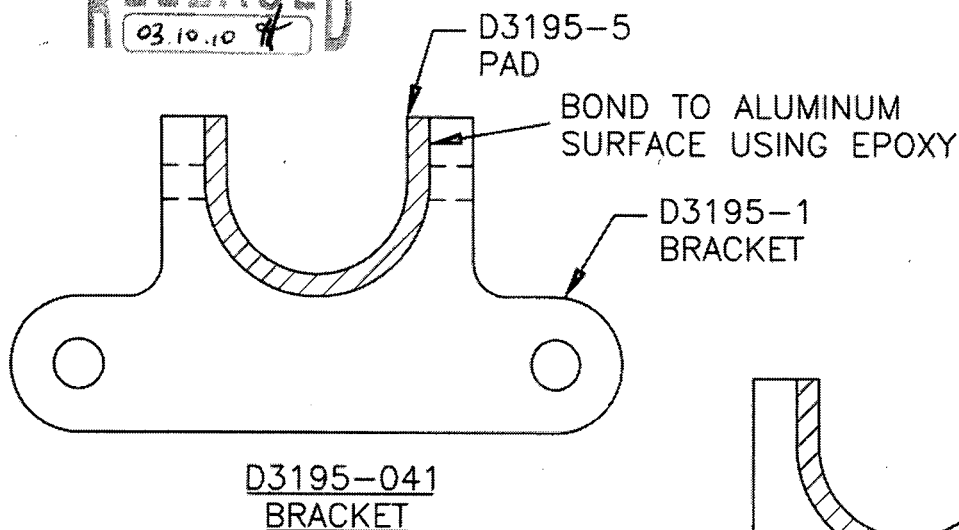
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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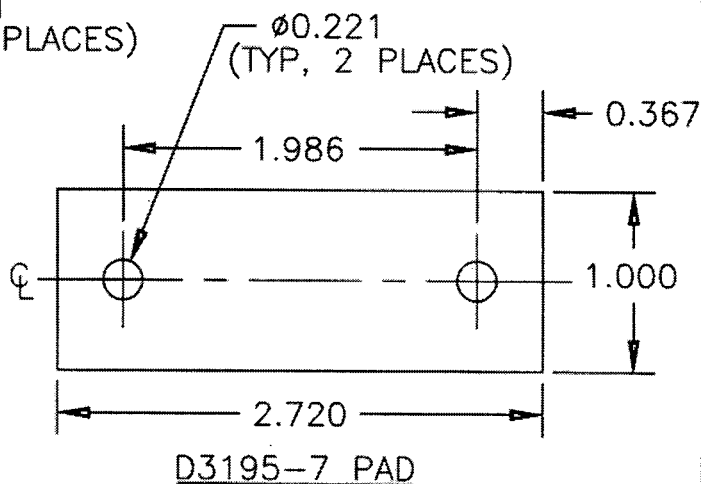
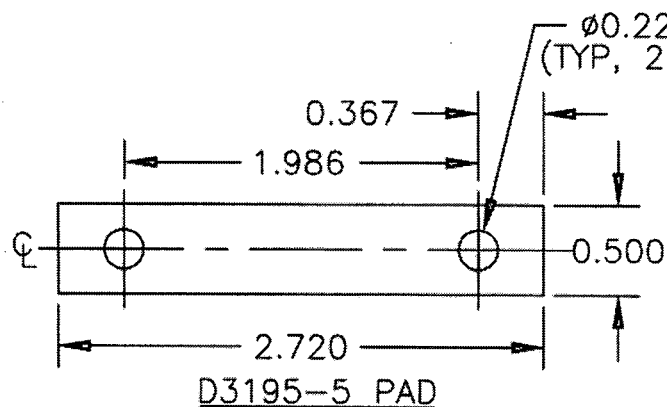
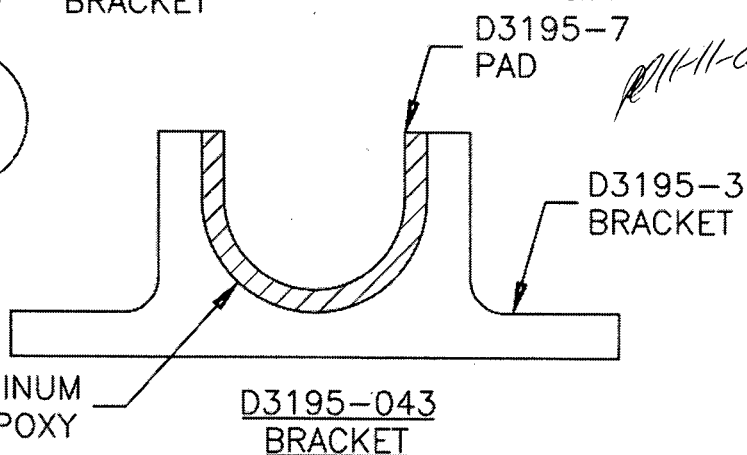


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DATE 03.06.23		TITLE BRACKET	SCALE 1:1
A	03.06.23	NEW ISSUE	

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03.10.10



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76207



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

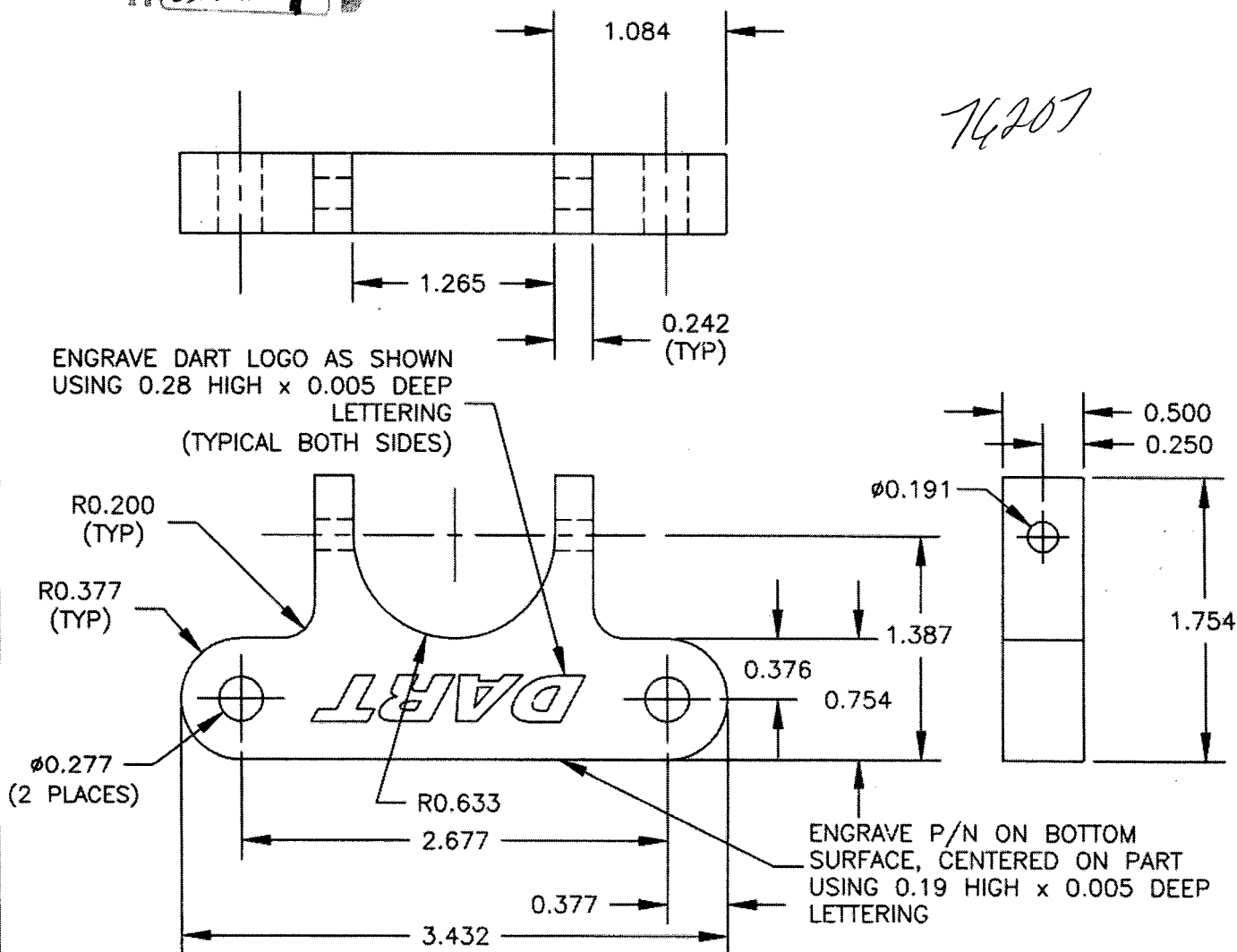
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DATE 03.06.23		TITLE BRACKET	SCALE 1:1

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03.10.10



D3195-1 BRACKET

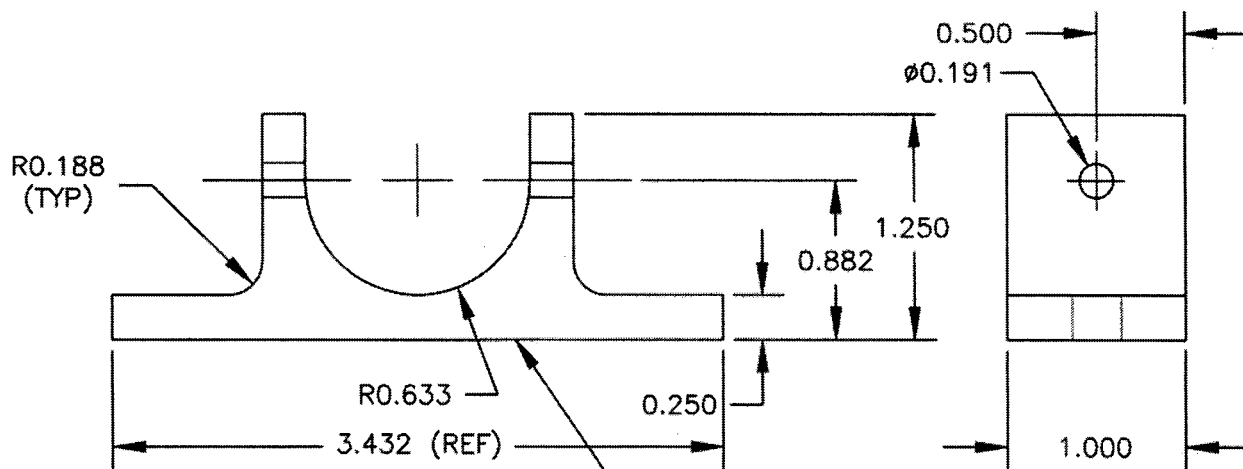
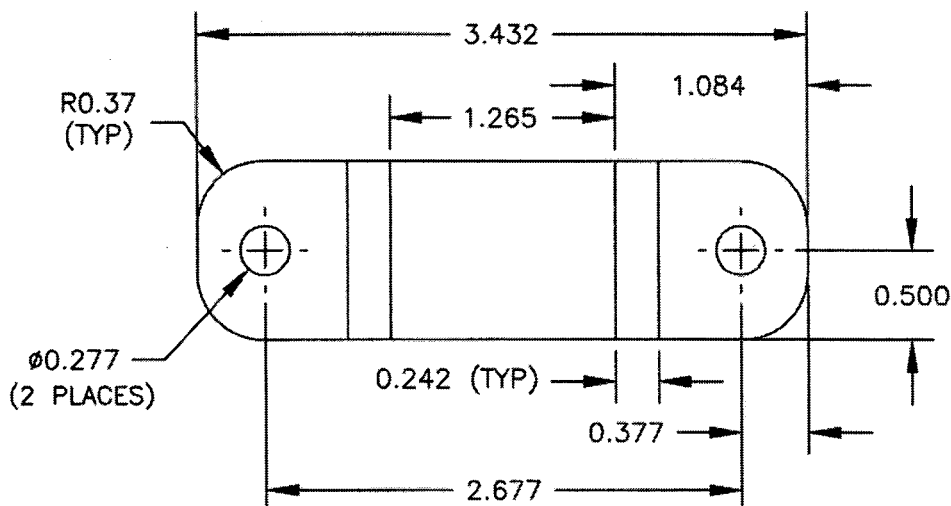
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



RELEASED
03.10.10

D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
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1393 Major Road
Orleans, ON
K1E 1H3

Phone # 613-899-2405

Packing Slip

Date	Invoice #
2/23/2012	57

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
15679	2/23/2012	Pick-Up	Archer	

Qty	Item Code	Description
10	Sales	D3195-1 HST (ON) on sales



1393 Major Road
Orleans, Ontario
K1E 1H3

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

Po Number	Part Number	Quantities
15679	D3195-1	10

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 15625 issued by Dart Aerospace Inc.

A handwritten signature in black ink, appearing to read "Alex Mazerolle".

Alex Mazerolle
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3